

Work Order ID 131505

131505

D205-541-049

Monday, April 13, 2015 10:04:04 AM

Item ID: D3053-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 212 Basket Base Assembly
 Start Date: 4/13/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/1/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: UMF Date: 15-4-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3053	C

100 Large Fab 0.00 ***100*** APR 29 2015 DAS 24 5-39

Large Fab Memo 0.04
 1-Cut 5 D2235-3 FROM D3166-1 using DT8365
 2-Cut Ribs from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing as per dwg.
 3-Remove all markings from material
 4-Drill holes in D3053-3 as per dwg D3053
 5-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995
 6- Cut mesh as per dwg

110 Weld per dwg A/R S.S. rod Batch: B125054 0.00 ***110***
 Large Fab Memo 0.04
 1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required 1x CC 15-5-4

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[illegible]

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M131545</i> Memo START TIME: <i>10:45</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>11:15</i>	0.00 0.01				<i>1</i>	<i>15-5-7</i>	<i>DAS</i>	<i>34 9:59</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>	<i>15-5-7</i>	<i>DAS</i>	<i>34 9:59</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>D-205-544-044</i> Memo	0.00		<i>131513</i>		<i>1</i>	<i>15-5-7</i>		

Monday, April 13, 2015 10:04:04 AM

Item ID: D3053-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 212 Basket Base Assembly

Start Date: 4/13/2015 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 5/1/2015 Req'd Qty: 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

0.00

OC

Memo

Quality Control

Number Stamp
15/5/11 JF

mf
15-5-11

Picklist Print

Monday, April 13, 2015 10:04:04 AM

Page 1

Work Order ID: 131505

131505

Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF
IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-1		Manufactured	No			100	Each	19.0000	5	5			DAS 24 9-89

D3166-1

Basket Hoop

Location	Loc Qty	Loc Code
WA004	19	
125268	1	
125270	6	
127860	12	

**

APR 29 2015

125269 → 5

M304EX0.75-16F Purchased No

100 sf 1,014.861 48 51

DAS
24
9-89

M304EX0 75-16F

Expanded Metal Flat SS

Location	Loc Qty	Loc Code
WA004	446	
M131848	446	
WA006	568.8612	
M131107	129.8612	
M131629	439	

**

APR 29 2015

51

M304TS0.750W.065 Purchased No

100 f 997.3500 43.3333 46

DAS
24
9-89

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
WA004	997.35	
125513	14	
m128495	389.35	
m131206	594	

**

APR 29 2015

46

Picklist Print

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Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

110 Each 36.0000 2 2

D2232-3

APR 29 2015

DAS
24
9-39

Basket Hinge

Location

Loc Qty

Loc Code

WA004

36

101778

16

115847

20

2

D2327-3 Manufactured No

110 Each 46.0000 2 2

D2327-3

APR 29 2015

DAS
24
9-39

Spacer Bushing

Location

Loc Qty

Loc Code

WA004

46

100523

25

103679

21

2

D2581 Manufactured No

110 Each 91.0000 2 2

D2581

APR 29 2015

DAS
24
9-39

Mounting Bracket

Location

Loc Qty

Loc Code

WA004

91

102265

36

127716

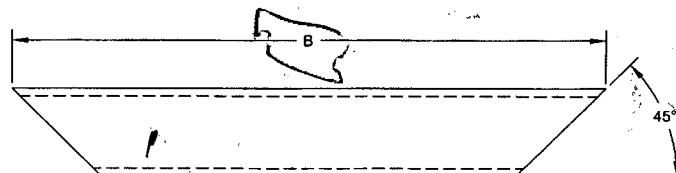
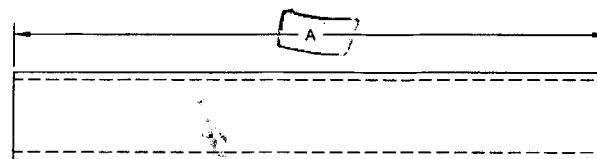
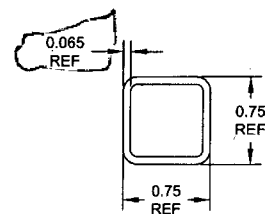
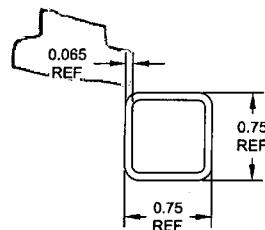
39

131144

16

2

QTY -041	QTY -042	PART NO	LENGTH A	LENGTH B	DESCRIPTION
X		D3053-041	N/A	N/A	BASKET BASE ASSY
	X	D3053-042	N/A	N/A	BASKET BASE ASSY
2	2	D3053-1		96.00	RIB
2	2	D3053-3		25.50	RIB
6	6	D3053-5	23.73		RIB
3	3	D3053-7	25.31		RIB
3	3	D3053-9	19.48	N/A	RIB
2	2	D2327-3	N/A	N/A	BUSHING
2	2	D2581	N/A	N/A	MOUNTING BRACKET
2	2	D2232-3	N/A	N/A	HINGE PLATE
5	5	D2235-3	N/A	N/A	RIB



D3053-X RIB

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

C	ADD -041 VIEWS, ZN B4-2, D4-2, B7-2. RE-ORGANIZE DWG. REF NCR13-2766.	DC	13.12.12
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

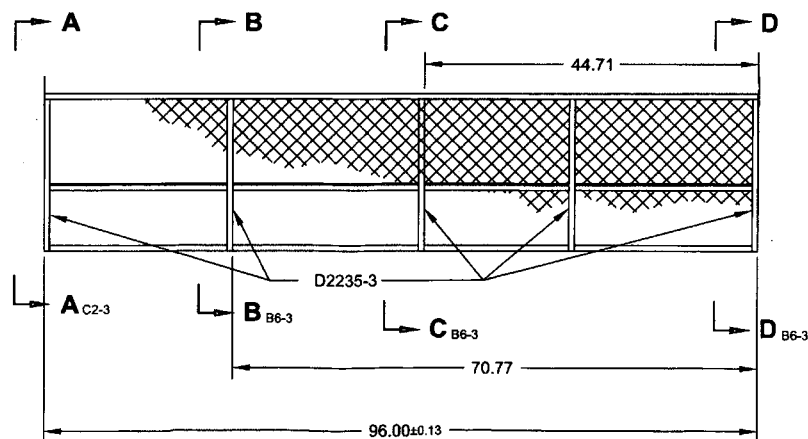
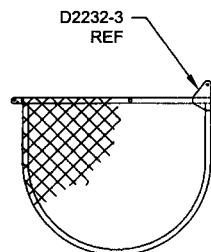
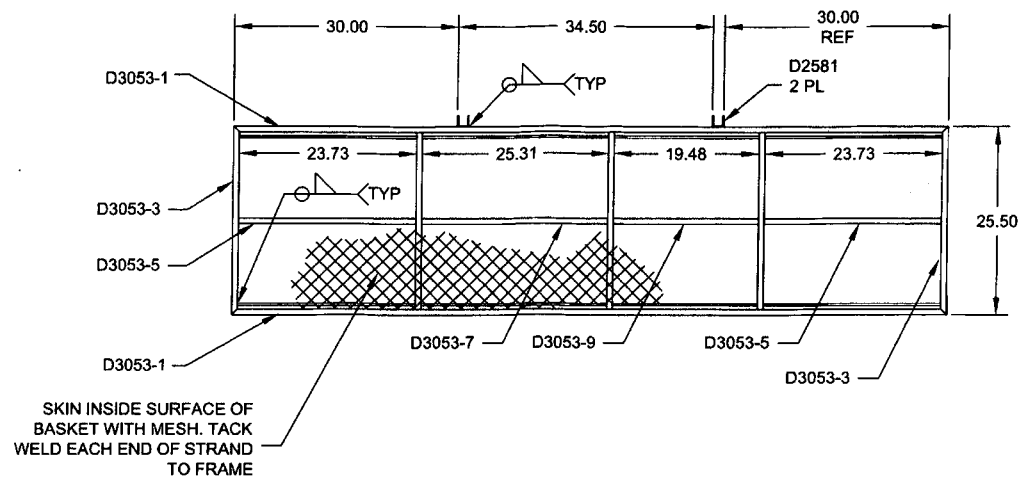


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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D3053-041 BASKET BASE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

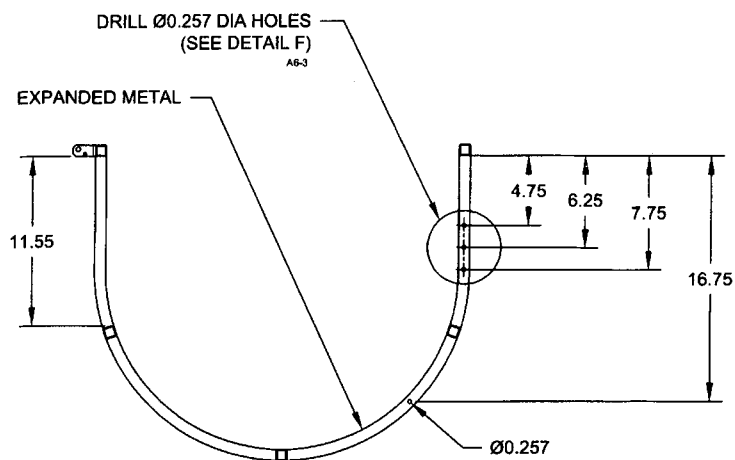


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

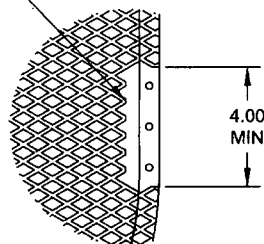
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Misidentified ☐	Past Due ☐	OTHER : _____			

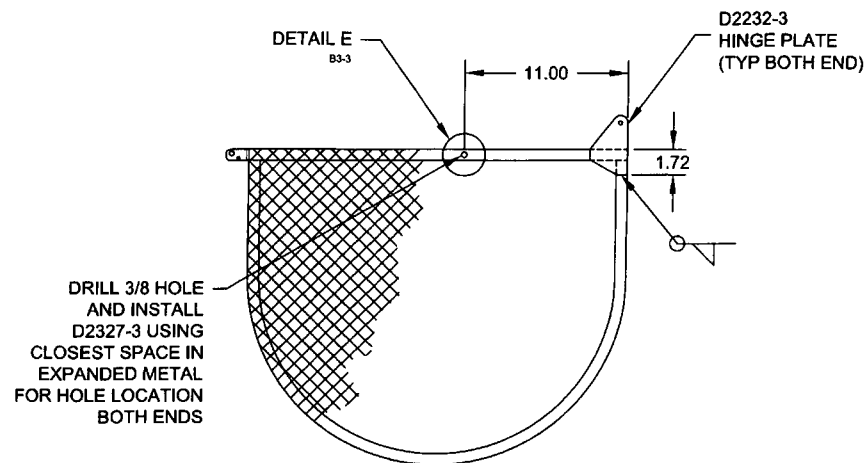


SECTION B-B
SECTION C-C
AND SECTION D-D
RIB DETAIL

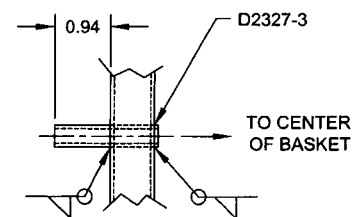
CUT AWAY EXPANDED
METAL TO NEAREST
INTERSECTIONS AS SHOWN
SECTION D-D ONLY



DETAIL F
SCALE NONE



SECTION A-A
SPACER DETAIL



DETAIL E
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



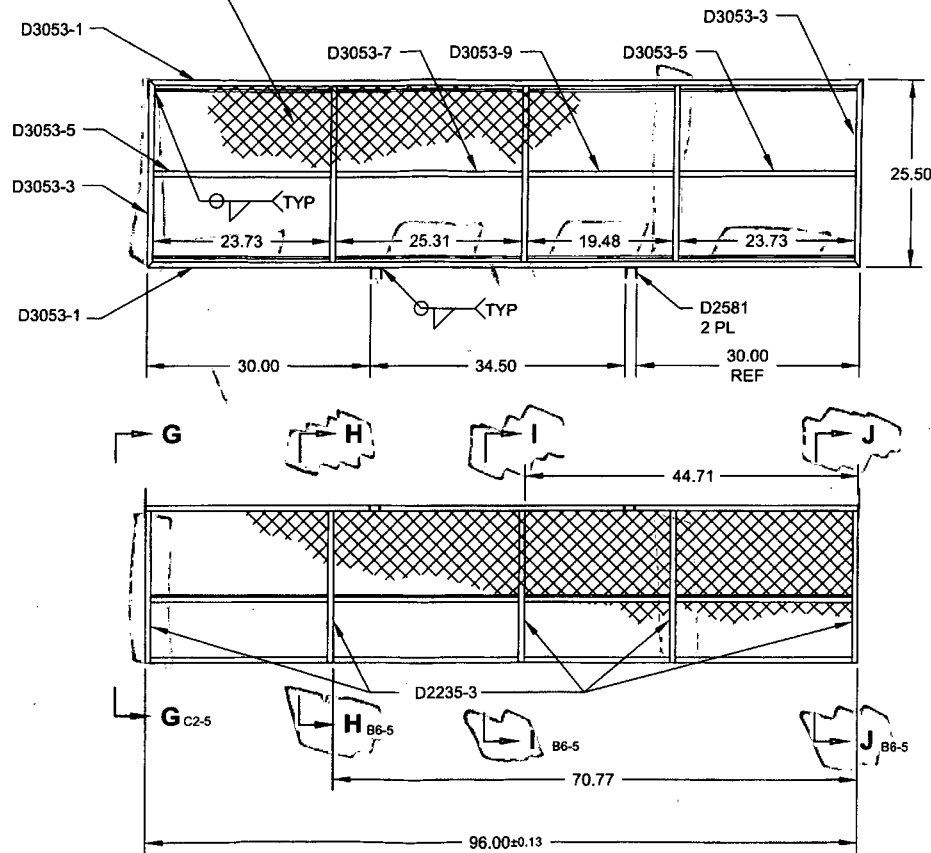
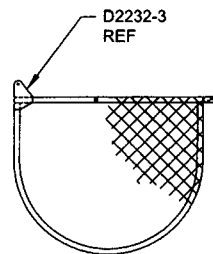
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



D3053-042 BASKET BASE ASSEMBLY SHOWN

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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DQA: _____ Date: _____

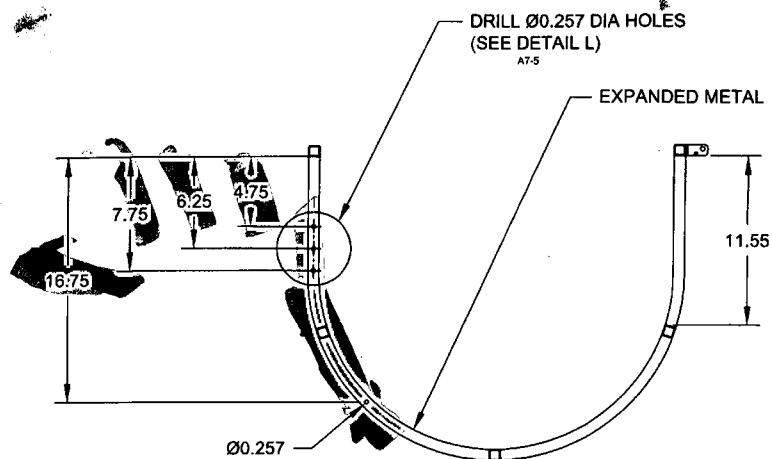


WORK ORDER NON-CONFORMANCE / UPDATE

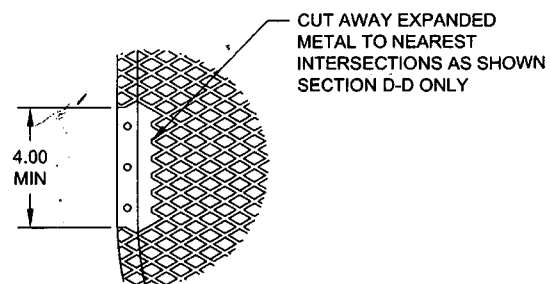
QA Closed: _____ Date: _____

Work Order update only ☐

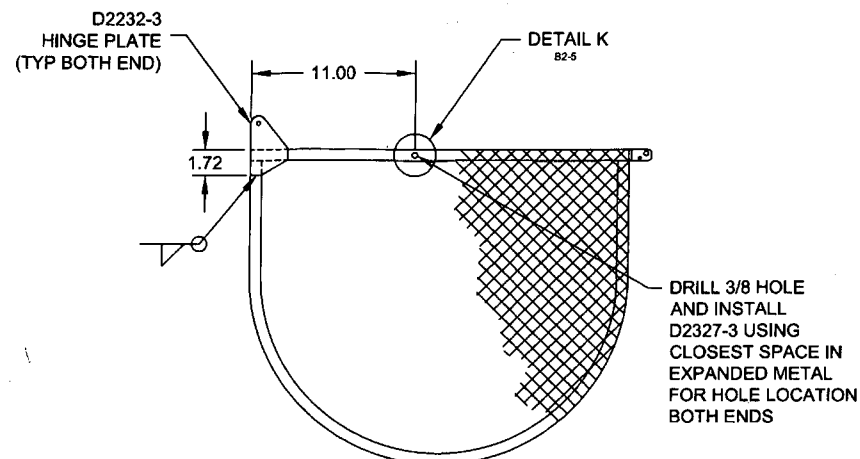
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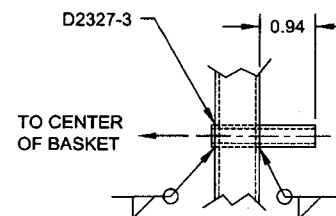
**SECTION H-H_{B5-4}
SECTION I-I_{B4-4}
AND SECTION J-J_{B3-4}**
RIB DETAIL



DETAIL L
SCALE NONE
C7-5



SECTION G-G_{B6-4}
SPACER DETAIL



DETAIL K
SCALE 4X
D3-5

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 5 OF 5
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	
		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____

Root Cause	FAULT CATEGORY							
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